

Work Order ID 56264



Page 1

Wednesday, February 17, 2010 11:05:05 AM

Item ID: D206-642-341

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 2/18/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 3/4/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-341

CHG003

10.02.22

pto →

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Deburr Fwd edge of tube 2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650 3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required. 4-Grind weld flush to cap on top surface only. 5-Cut af

M112507
M113207

112 DP 10-2-17

BE 10-2-18

120

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

M1012123

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Seq 110

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R

Aluminum Rod

M112507 / M113207 DE 10/02/22

4-Grind weld flush to cap on top surface only.

5-Cut aft end to length as per dwg D2650

M 10/2/22

6-Drill pilot holes using drill Jig DT8168A (A, & B) and DT8025. Open to $\varnothing 0.312$ "

7-Drill holes for wearplates using DT 8028-5. Open to $\varnothing 0.297$ ".

M 10/2/23

8-Open Aft Cap Hole using #6 Drill Bit

9-Open holes for Tow Ring to $\varnothing 0.625$ " as per Dwg D2650, D2650-5 Drilling Detail

10-Remove inner indexing ridge on aft end of skid tube as per Dwg D2650

M 10/2/22

11-Deburr and Blow out all chips from inside the tube

M 10/2/23

Seq 130

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650 (without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting

M 10/2/23

Start Date: 10/2/23 Time: 10:30 am

Finish Date: 10/02/24 Time: 8:20 am

A/R

Sikaflex-291

M 112429

Sikaflex expiry date:

10/8/30

~~Deburr Fwd edge of tube~~

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R

Aluminum Rod

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Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid) 2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid) 3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer. 4-Bond D26

11/22/23

pto

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/24

70

150

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. A/RAluminum Rod m112507 2-Grind welds flush as per Dwg D2650. Masking Tape access to

BE 10/2/25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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| | | | | | | | | |

NOTE: Date & initial all entries

Seq 150

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R

Aluminum Rod M112507 *BE 10/02/25*

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube *BE 10/02/25*

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Debur

BE 10/02/25

11/02/25 4- Install nut plate as per dwg

BE 10/02/25

Seq 190

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

Seq 220

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R

Sikaflex-291 _____

Sikaflex expiry date: _____

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R

Sikaflex-291 _____

Sikaflex expiry date: _____

6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4

Batch: _____

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Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

Install D2680-041 Nut Plate as per Dwg D2650

8/E 10/02/25

170

0.00



QC

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

Quality Control

8/10/02/25



180

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

8/10/02/25



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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00



+Recalodine AS PER PAR09-043

0.00

u

10/03/09

(X1)

Ø

HandFinish

Memo

Hand Finishing

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



M113170

Powdercoat

Memo

0.00

=> u

10/03/09

(X1)

Ø

Powder Coating

START TIME:

1:15pm

OVEN TEMPERATURE:

1:45pm FINISH TIME:

320°F

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

BR 10-03-2009

Ø

Ø

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Start Date: 2/18/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 3/4/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 220 | HandFinishing | 0.00 | | | | | | | |
| | HandFinish | | | | | | | | |
| | Hand Finishing | | | | | | | | |
| | Memo | 0.00 | | | | | | | |
| | 1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. <input type="checkbox"/> A/R Sikaflex- 291 <u>112345</u> <input type="checkbox"/> Sikaflex expiry date: <u>10/08</u> <input type="checkbox"/> 2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly <i>Memo 22 Wing Walk Batch 113462</i> | | | | | | | | |
| 230 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| | QC | | | | | | | | |
| | Quality Control | | | | | | | | |
| | Memo | 0.00 | | | | | | | |
| 240 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| | QC | | | | | | | | |
| | Quality Control | | | | | | | | |
| | Memo | 0.00 | | | | | | | |

BR 10-3-23

S 10/5/24

S 10/6/21

(40)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 56264



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Wednesday, February 17, 2010 11:05:05 AM

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Revision ID:

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Item Name: Replacement Skidtube

Start Date: 2/18/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 3/4/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-341 Location: _____ □ PPP Rev: _____

PP 56260

C 10/4/90

260

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/12

MF 10-4-8

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Wednesday, February 17, 2010 11:05:05 AM

Page 1

Work Order ID: 56264



Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP Rev: H:05.10.11 Added D3429-1 per CHG004 LKJ/CP/JLM
IPP Rev: I 08-09-29 revF as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| ALS4-1032-130 | | Purchased | No | | | | Each | 1,908.000 | 54.0000 | | | |



Insert



| Warehouse Location | Loc Qty | Loc Code |
|-----------------------|---------|----------|
|-----------------------|---------|----------|

Main Warehouse

ST

1908

110511 ✓

1908

Each

388.0000

54.0000

AN960C10L

Purchased

No



washer



54. BR 10-3-23.

| Warehouse Location | Loc Qty | Loc Code |
|-----------------------|---------|----------|
|-----------------------|---------|----------|

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

288

112116

128

112612

160

NAS 1149 C03322.

54. BR 10-3-23.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Comments: IPP Rev: H005.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
IPP Rev: I 08-09-29 revF as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

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|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| AN960JD10L | | Purchased | No | | | | Each | 3,457.000 | 2.0000 | | | |



Washer



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 3457

101291 16

105793 49

110985 3392

AN960JD416

Purchased

No

Each

0.0000

1.0000



Washer

CCR264SS3-3

Purchased

No

Each

521.0000

2.0000



Cherry Rivet

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 29

111548 20

111827 1

112314 2

113539 6

Main Warehouse

ST311 492

113973 492

2 BR 10-3-23.

1 BR 10-3-23.

2 BE 10/02/25

Wednesday, February 17, 2010 11:05:05 AM

Shop Packet Print

Page 2

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Comments: IPP Rev: H05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
IPP Rev: I 08-09-29 revF as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| CR3212-4-03 | | Purchased | No | | | | Each | 242.0000 | 2.0000 | | | |



Cherry Rivet



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

242

111359

84

112314

158

D2620

Manufactured No

Each

10.0000

1.0000



Skidtube, 206 Skidtube



2 8E 10-02-25

Warehouse

Loc Qty

Loc Code

Location

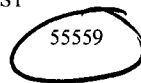
Main Warehouse

ST

10

55559

10



DP 10-2-17

Wednesday, February 17, 2010 11:05:05 AM

Shop Packet Print

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Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2646 | | Manufactured | No | | | | Each | 55.0000 | 1.0000 | | | |



Aft Cap



Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP6

29

52663 ✓

29

Main Warehouse

fp7

13

52663

13

Main Warehouse

ST

13

46327

4

48109

9

D2647

Manufactured No

Each

90.0000

1.0000



Cap



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

90

55352

90

1 BL 10-3-23

1 BE 12/02/18

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Wednesday, February 17, 2010 11:05:05 AM

Work Order ID: 56264



Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
IPP Rev: I 08-09-29 revF as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2649 | | Manufactured | No | | | | Each | 245.0000 | 19.0000 | | | |



Cross Bolt Spacer



| Warehouse Location | Loc Qty | Loc Code |
|-----------------------|---------|----------|
|-----------------------|---------|----------|

Main Warehouse

| | | |
|----|-----|--|
| LG | 218 | |
|----|-----|--|

| | | |
|-------|---|--|
| 51529 | 3 | |
|-------|---|--|

| | | |
|-------|-----|--|
| 55000 | 215 | |
|-------|-----|--|

Main Warehouse

| | | |
|----|----|--|
| ST | 27 | |
|----|----|--|

| | | |
|-------|---|--|
| 36013 | 5 | |
|-------|---|--|

| | | |
|-------|----|--|
| 47112 | 18 | |
|-------|----|--|

| | | |
|-------|---|--|
| 48271 | 4 | |
|-------|---|--|

D2651-1 Manufactured No



Plug

| | | |
|------|----------|---------|
| Each | 450.0000 | 14.0000 |
|------|----------|---------|



| Warehouse Location | Loc Qty | Loc Code |
|-----------------------|---------|----------|
|-----------------------|---------|----------|

Main Warehouse

| | | |
|-----|-----|--|
| fpa | 295 | |
|-----|-----|--|

| | | |
|-------|-----|--|
| 53349 | 295 | |
|-------|-----|--|

Main Warehouse

| | | |
|----|-----|--|
| ST | 155 | |
|----|-----|--|

| | | |
|-------|-----|--|
| 51530 | 155 | |
|-------|-----|--|

19 BE 10/02/25

14 BR 10-3-23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, February 17, 2010 11:05:05 AM

Work Order ID: 56264



Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP Rev: H105.10.11 Added D3429-1 per CHG0041 KJ/CP/JLM
IPP Rev: I 08-09-29 revF as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2651-3 | | Manufactured | No | | | | Each | 639.0000 | 14.0000 | | | |
| | | | | | | | | | | | | |
| O-Ring | | | | | | | | | | | | |

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 639
43849 3
46114 636 ✓

D2654-5

Web

Manufactured No

Each 4.0000 1.0000

14, DR 10-3-23

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 4
46638 4

D2680-041

Nut Plate

Manufactured No

Each 54.0000 1.0000

1 11/2/23

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST021 54
33061 1
55366 53

1 3E 10/02/25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Page 7

Wednesday, February 17, 2010 11:05:05 AM

Work Order ID: 56264



Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP Rev: H05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
IPP Rev: I 08-09-29 revF as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3535-11 | | Manufactured | No | | | | Each | 8.0000 | 1.0000 | | | |
| | | | | | | | | | | | | |
| Wearshoe | | | | | | | | | | | | |

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

46647 ✓

8

8

Each

10.0000

1.0000



1 BR 10-3-23

D3535-23



Wearshoe

Manufactured No

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

53467 ✓

10

10

Each

17.0000

1.0000



1 BR 10-3-23

D3535-35



Wearshoe

Manufactured No

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

51608 ✓

17

17

1 BR 10-3-23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Page 8

Wednesday, February 17, 2010 11:05:05 AM

Work Order ID: 56264

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP Rev: H105.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
IPP Rev: I 08-09-29 revF as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3536-11 | | Manufactured | No | | | | Each | 16.0000 | 1.0000 | | | |



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

16

46649 ✓

12

46715

4

Each

16.0000

1.0000

D3536-23

Manufactured

No



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

3

51609

3

Main Warehouse

ST

13

30754 ✓

1

53468 ✓

12

1 BL 10-3-23.

1 BL 10-3-23.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, February 17, 2010 11:05:05 AM

Work Order ID: 56264



Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
IPP Rev: I 08-09-29 revF as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3536-35 | | Manufactured | No | | | | Each | 19.0000 | 1.0000 | | | |
| | | | | | | | | | | | | |
| Gasket | | | | | | | | | | | | |

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

19

51628 ✓

19

Each

153.0000

6.0000



1 BR 10-3-23.

D3537-1



Wearpad

Manufactured

No

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP

74

48288 ✓

2

55465 ✓

72

Main Warehouse

FP17

79

51678

1

51679

78

6 BR 10-3-23.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, February 17, 2010 11:05:05 AM

Work Order ID: 56264



Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP Rev: H105.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
IPP Rev: I 08-09-29 revF as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3537-3 | | Manufactured | No | | | | Each | 32.0000 | 1.0000 | | | |



Wearpad

| Warehouse Location | Loc Qty | Loc Code |
|-----------------------|---------|----------|
|-----------------------|---------|----------|

Main Warehouse

| | | |
|----|----|--|
| ST | 32 | |
|----|----|--|

| | | |
|-------|---|--|
| 33881 | 4 | |
|-------|---|--|

| | | |
|---------|----|--|
| 35697 ✓ | 28 | |
|---------|----|--|

MS27039-1-08

Purchased

No

| | | |
|------|-----------|---------|
| Each | 2,169.000 | 54.0000 |
|------|-----------|---------|



Screw

| Warehouse Location | Loc Qty | Loc Code |
|-----------------------|---------|----------|
|-----------------------|---------|----------|

Main Warehouse

| | | |
|----|------|--|
| ST | 2169 | |
|----|------|--|

| | | |
|--------|---|--|
| 110467 | 3 | |
|--------|---|--|

| | | |
|----------|-----|--|
| 110552 ✓ | 166 | |
|----------|-----|--|

| | | |
|--------|------|--|
| 110835 | 2000 | |
|--------|------|--|

1 BR 10-3-23.

54 BR 10-3-23.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Page 11

Wednesday, February 17, 2010 11:05:05 AM

Work Order ID: 56264



Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP Rev: H05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
IPP Rev: I 08-09-29 revF as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| MS27039-1-08 | | Purchased | No | | | | Each | 2,169.000 | 2.0000 | | | |



Screw

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 2169

110467 3

110552 166

110835 2000

MS27039-4-06 Purchased No

Each 49.0000 1.0000



Screw

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 49

109061 49

2 Bl 10-3-23

1 Bl 10-3-23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| QTY -1 | QTY -3 | QTY -5 | QTY -7 | PART NUMBER | DESCRIPTION |
|-----------|-----------|-----------|-----------|---------------|---|
| X | | | | D2650-1 | SKIDTUBE ASSEMBLY |
| | X | | | D2650-3 | SKIDTUBE ASSEMBLY |
| | | X | | D2650-5 | SKIDTUBE ASSEMBLY |
| | | | X | D2650-7 | SKIDTUBE ASSEMBLY |
| 1 | 1 | 1 | 1 | D2600-1-160 | EXTRUSION |
| 1 | | | | D2654-1 | WEB |
| | 1 | | | D2654-3 | WEB |
| | | 1 | | D2654-5 | WEB |
| | | | 1 | D2654-7 | WEB |
| 1 | 1 | 1 | 1 | D2646 | AFT CAP |
| 1 | 1 | 1 | 1 | D2647 | CAP |
| 17 | 18 | 19 | 23 | D2649 | CROSS BOLT SPACER |
| 16 | 18 | 14 | 22 | D2651-1 | PLUG |
| 16 | 18 | 14 | 22 | D2651-3 | O-RING |
| 1 | 1 | 1 | 1 | D2680-041 | NUT PLATE |
| 2 | 2 | | | D3286-1 | DOUBLER |
| 2 | 2 | | | D3286-3 | STUD |
| 42 | 44 | 54 | 60 | ALS7-1032-130 | INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130) |
| 2 | 2 | 2 | 2 | AN960JD10L | WASHER |
| 2 | 2 | 2 | 2 | CCR264SS3-3 | RIVET |
| 2 | 2 | 2 | 2 | CR3212-4-03 | RIVET |
| 2 | 2 | 2 | 2 | MS27039-1-08 | SCREW |
| 1 | 1 | 1 | 1 | MS27039-4-06 | SCREW |
| 1 | 1 | 1 | 1 | AN960JD416 | WASHER |
| 52 | 52 | | | CR3212-4-04 | RIVET |

F

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

| | | | |
|------------|--|--|--------------|
| F | DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239). | AJS | 08.08.08 |
| E | RMOVE CBORE, CHG DRILL, ADD CHAMFER | CP | 06.03.30 |
| D | REDRAW; INCCORP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3 | CP | 04.05.17 |
| C | CHANGE HOLE PATTERN AND FRONT END | DS | 97.10.29 |
| B | AS MANUFACTURED CHANGES | DS | 97.06.26 |
| A | NEW ISSUE | DS | 97.03.25 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | DS | DART AEROSPACE USA, INC | |
| DRAWN | AJS | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. F |
| MFG. APPR. | | D2650 | SHEET 1 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 206/407 SKIDTUBE ASSEMBLIES | NTS |
| DATE | 08.08.08 | COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. | |

RELEASED
08-07-23 117

456264

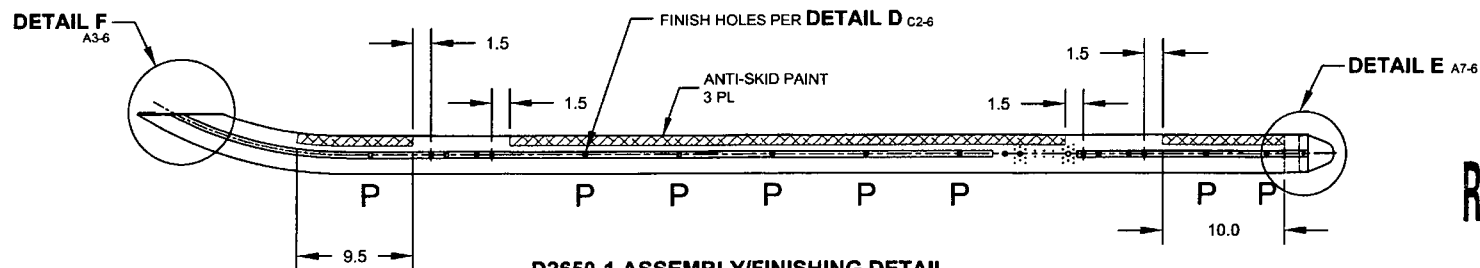
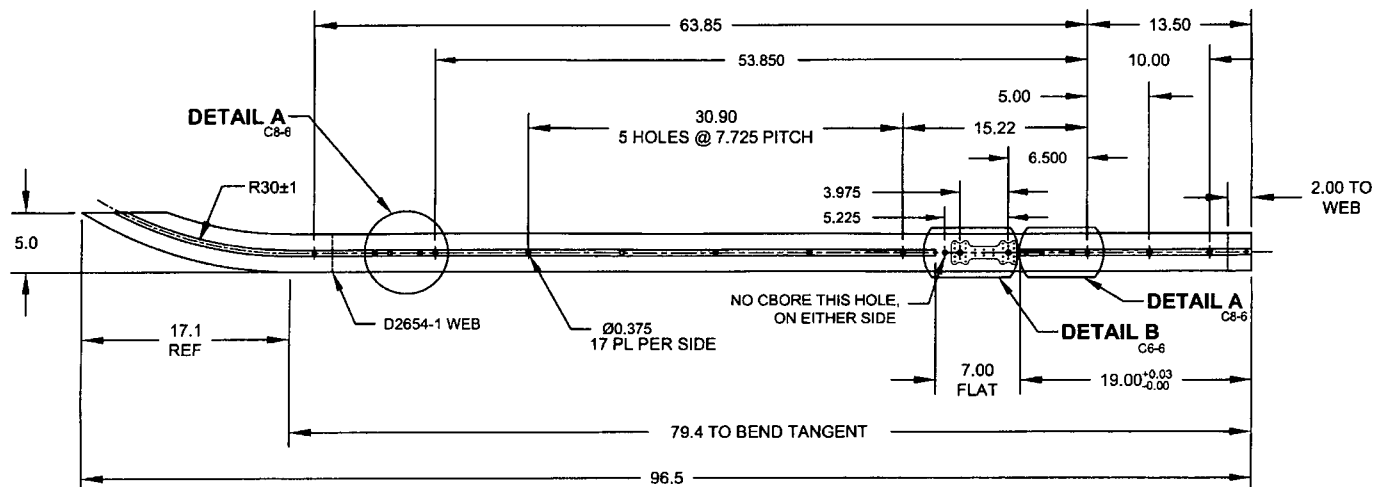
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



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| DESIGN | DS | DART AEROSPACE USA, INC | |
| DRAWN | AJS | PORT HADLOCK, WA | |
| CHECKED |  | DRAWING NO. | REV. F |
| MFG. APPR. |  | D2650 | SHEET 2 OF 6 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | 206/407 SKIDTUBE ASSEMBLIES | NTS |
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680922/11/1

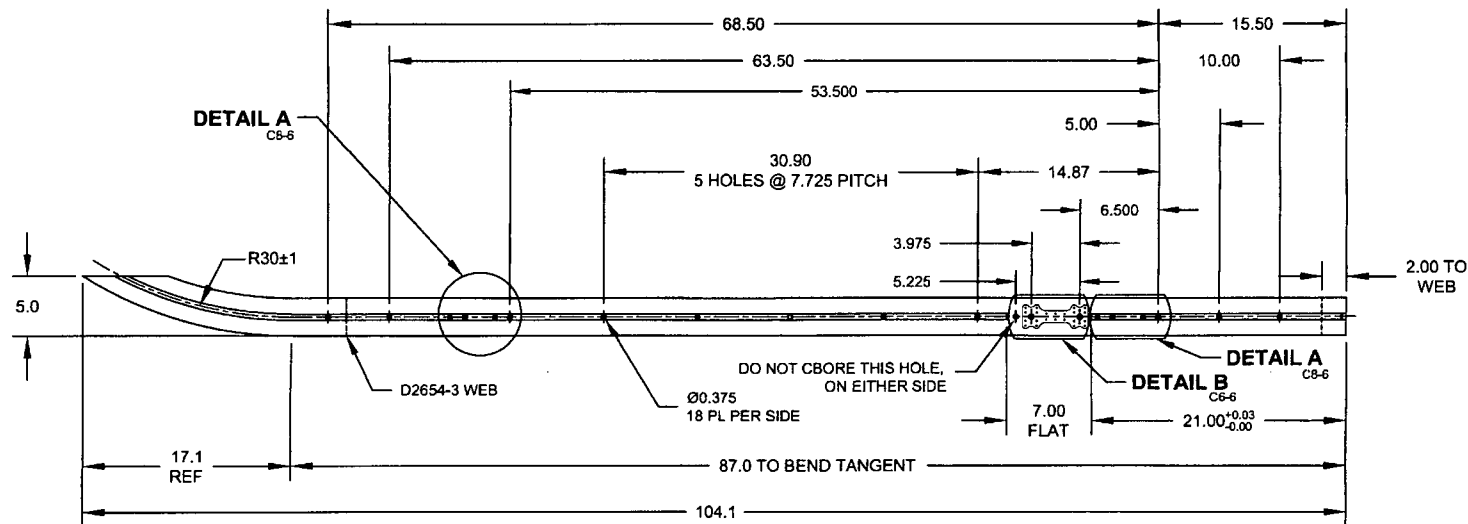
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

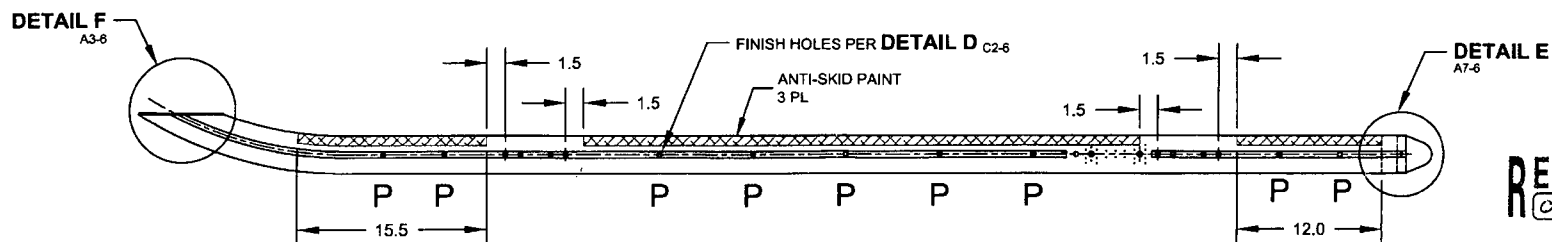
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



D2650-3 BENDING/DRILLING DETAIL



D2650-3 ASSEMBLY/FINISHING DETAIL

RELEASED
08 07 22 1118

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|------------|----------|--|--------------|
| DESIGN | DS | DART AEROSPACE USA, INC | |
| DRAWN | AJS | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. F |
| MFG. APPR. | | D2650 | SHEET 3 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 206/407 SKIDTUBE ASSEMBLIES | NTS |
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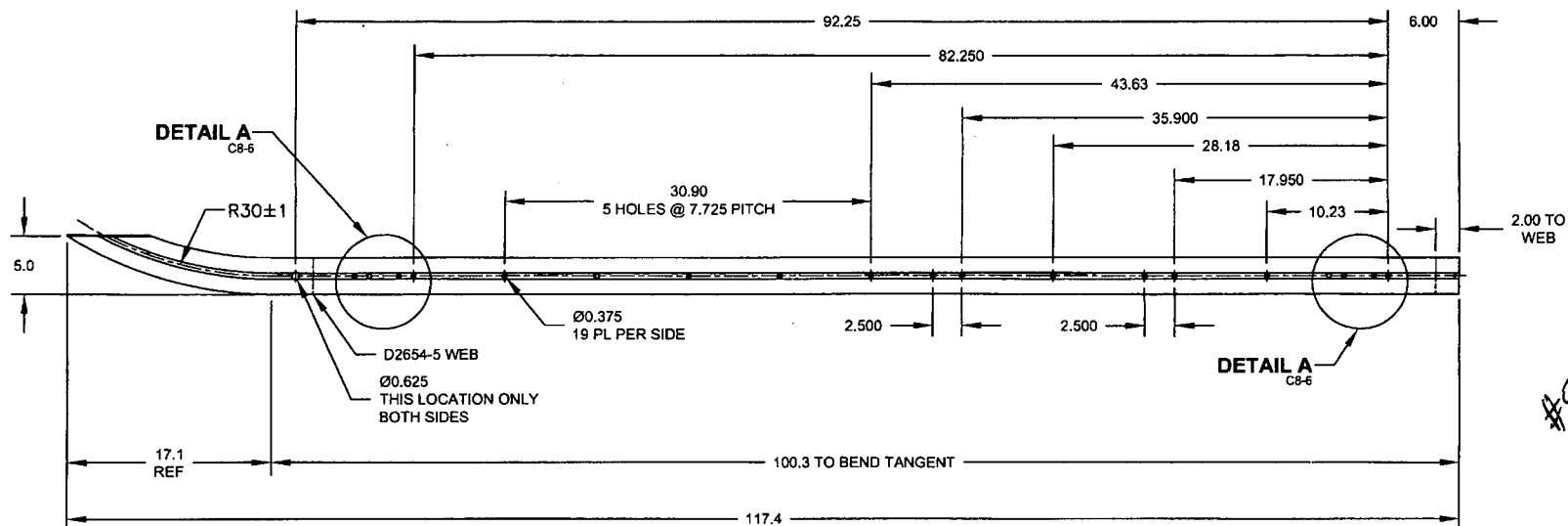
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

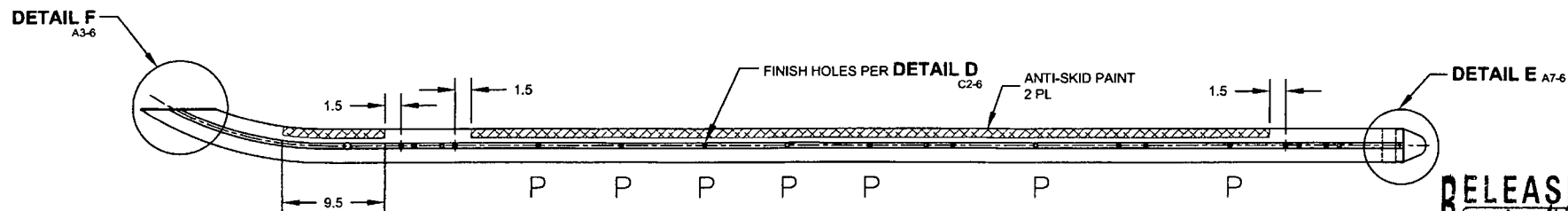
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



D2650-5 BENDING/DRILLING DETAIL



D2650-5 ASSEMBLY/FINISHING DETAIL

| | | | |
|------------|--------------------|--|--------------|
| DESIGN | DS | DART AEROSPACE USA, INC | |
| DRAWN | AJS | PORT HADLOCK, WA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. F |
| MFG. APPR. | <i>[Signature]</i> | D2650 | SHEET 4 OF 6 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | 206/407 SKIDTUBE ASSEMBLIES | NTS |
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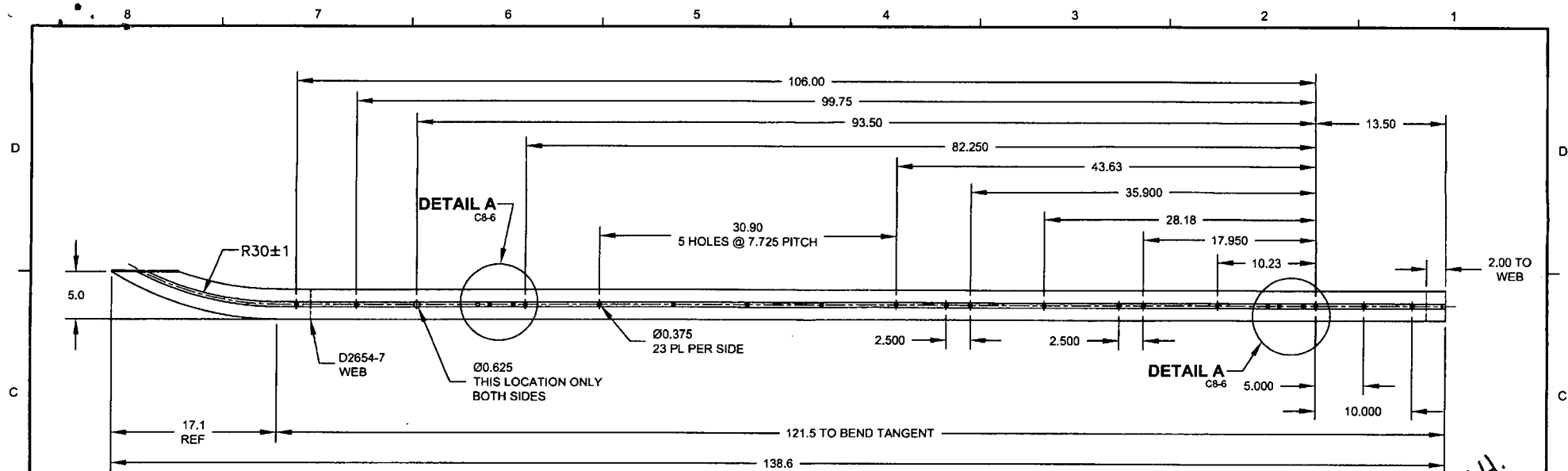
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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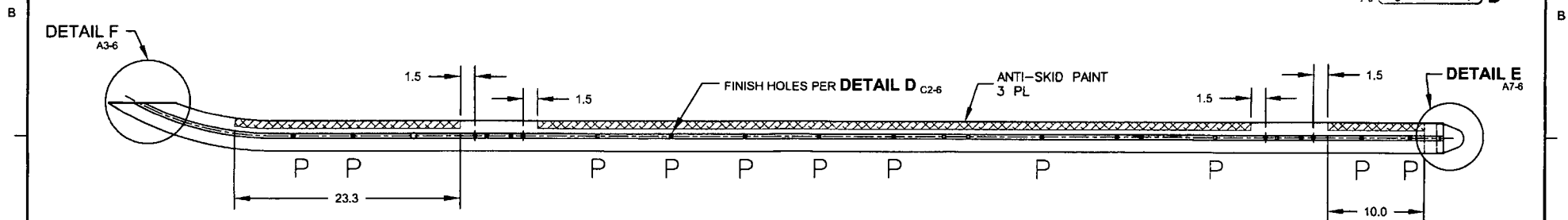
NOTE: Date & initial all entries



D2650-7 BENDING/DRILL DETAIL

#56264

RELEASED
08 07-22 11/17



D2650-7 ASSEMBLY/FINISHING DETAIL

| | | | |
|------------|----------|--|--------------|
| DESIGN | DS | DART AEROSPACE USA, INC | |
| DRAWN | AJS | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. F |
| MFG. APPR. | | D2650 | SHEET 5 OF 6 |
| APPROVED | | TITLE | SCALE |
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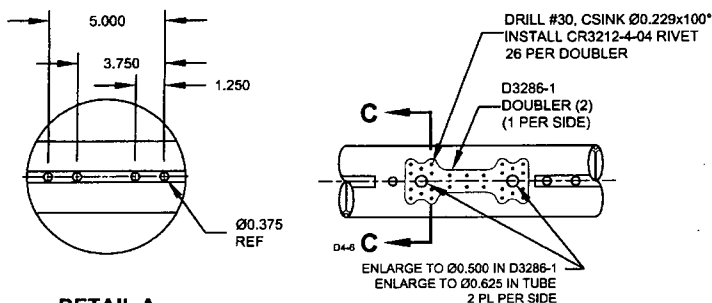
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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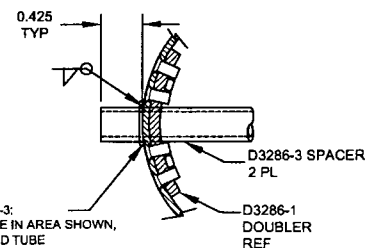
NOTE: Date & initial all entries



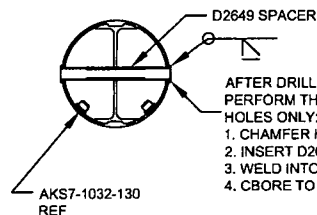
DETAIL A
SCALE 2X
C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D6-5

DETAIL B
SCALE 2X
C3-2
C3-3

SECTION C-C C7-6
SCALE NONE



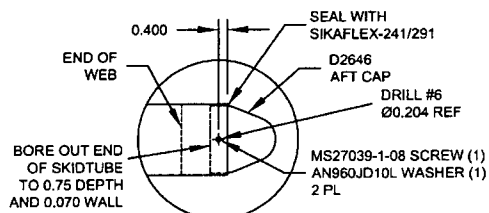
- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE.



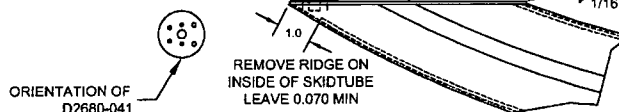
DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X
B4-2
B4-3
B4-4
B4-5

- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP

#56264



DETAIL E
SCALE 2X
B2-2
B2-3
B1-4
B1-5





DETAIL F
SCALE NONE
B8-2
B8-3
B8-4
B8-5

DETAIL F NOTES:

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED
08-09-22-199

| | | | |
|---|---|---|--------------|
| DESIGN | DS | DART AEROSPACE USA, INC | |
| DRAWN | AJS | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. F |
| MFG. APPR. | | D2650 | SHEET 6 OF 6 |
| APPROVED |  | TITLE | SCALE |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

NO. 323

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Berclay Elliott
Job number: 5577
Part number: 0206-642-441
Description: 206 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Rat. Inf Date of Test Coupon 10-02-16
Welder Berclay Elliott Date of Test Coupon 10-02-16

The above named individual is qualified in accordance with AWS D17.1.2001 to weld